



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-041
Job Sheet 172310



Part No: D205-634-041

Job Qty: 1 ea

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/15/18

Job Tracking No:

Due Date: 3/15/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/14/18	3/14/18	0.00	0.00	Start Up Skid tubes		2.8
110	CNC Bend Skid tubes	1 pcs	3/14/18	3/14/18	0.00	0.65	CNC Bend Skid tube		m.b.l.
120	Skid tubes	1 pcs	3/14/18	3/14/18	0.00	2.89	Skid tubes-2		5.4
130	QC	1 pcs	3/14/18	3/14/18	0.00	0.00	QC5		3.8
140	Skid tubes	1 pcs	3/14/18	3/14/18	0.00	2.89	Skid tubes-2		3.8
150	QC	1 pcs	3/14/18	3/14/18	0.00	0.00	QC10		3.8
160	QC	1 pcs	3/14/18	3/14/18	0.00	0.00	QC5		3.8
170	HandFinish	1 pcs	3/14/18	3/14/18	0.00	1.31	HandFinish2		3.8
180	Powdercoat	1 pcs	3/14/18	3/14/18	0.00	0.34	Powdercoat1		3.8
190	QC	1 pcs	3/14/18	3/14/18	0.00	0.00	QC3		3.8
200	HandFinish	1 pcs	3/15/18	3/15/18	0.00	1.31	HandFinish4		3.8
210	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC5		3.8
215	DC	1 pcs	3/15/18	3/15/18	0.00	0.00	DC		3.8
220	Packaging	1 pcs	3/15/18	3/15/18	0.00	0.00	Packaging3-1		3.8
230	QC21-FG	1 Ea	3/15/18	3/15/18	0.00	0.00	QC21		3.8

Part Op 110 - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe batch# in Descriptions: aft end of tube

120 - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

140 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

170 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - START TIME: 11:40 OVEN TEMPERATURE: 320° FINISH TIME: 11:40

200 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 11/38/20 Sikaflex expire date: 11/38/20 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 11/38/20 Sikaflex expire date: 11/38/20 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 11/38/20

210 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

215 - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	5053825
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	140-Skidtubes	5056023
D4202-1	Spacer	20 Ea (20 ea)	140-Skidtubes	5039216
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-HandFinish	5045668
AN3-5A	Bolt	2 Ea (2 ea)	200-HandFinish	5041106
AN3C4A	Bolt	50 Ea (50 ea)	200-HandFinish	5041114
D2594-1	Plug	16 Ea (16 ea)	200-HandFinish	5045169
D2594-3	O-Ring	16 Ea (16 ea)	200-HandFinish	5049975
D2855	Cap	1 Ea (1 ea)	200-HandFinish	5047805
D3564-11	Wearplate Aft	1 Ea (1 ea)	200-HandFinish	5048475
D3564-13	Wearpad Fwd	1 Ea (1 ea)	200-HandFinish	5040872
D3564-5	Wearplate Center	1 Ea (1 ea)	200-HandFinish	5041097
D3564-9	Wearplate Fwd	1 Ea (1 ea)	200-HandFinish	5045073
NAS1149C0332R	Washer	50 Ea (50 ea)	200-HandFinish	5044236
NAS1149D0332J	Washer	2 Ea (2 ea)	200-HandFinish	5020606

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	4	0
140-Skidtubes	D2576-3	1	37	0
	D4202-1	20	797	0
200-HandFinish	ALS7-1032-130	50	0	0
	AN3-5A	2	500	0
	AN3C4A	50	3,674	0
	D2594-1	16	316	0
	D2594-3	16	469	0
	D2855	1	64	0
	D3564-11	1	29	0
	D3564-13	1	37	0
	D3564-5	1	40	0
	D3564-9	1	21	0
	NAS1149C0332R	50	2,187	0
	NAS1149D0332J	2	3,786	0

Part Specifications	
Specifications could not be found.	

Gagnon.Michelle

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Email: sales@dartaero.com
www.dartaero.com

DART
AEROSPACE

Container No: S057154



Part: D205-634-041

Job No: 172310

Serial No/Batch: S057154

Revision: 1

Inspector:

Date: 04/02/18

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WITHOUT NOTICE
WORK ORDER

NO. 172310

FEB 14 2018

ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2565	AFT CAP
28	1	1			D3584-6	WEARSHOE
29	1	1			D3584-9	WEARSHOE
30	1	1			D3584-11	WEARSHOE
31	1	1			D3584-13	WEARSHOE
32	20	20	24	24	D4302-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5061-1	FWD WEARPLATE
36				1	D5061-3	AFT WEARPLATE
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN680C10L)
55	2	2	2	2	NAS1149C0332J	WASHER (AN680J10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

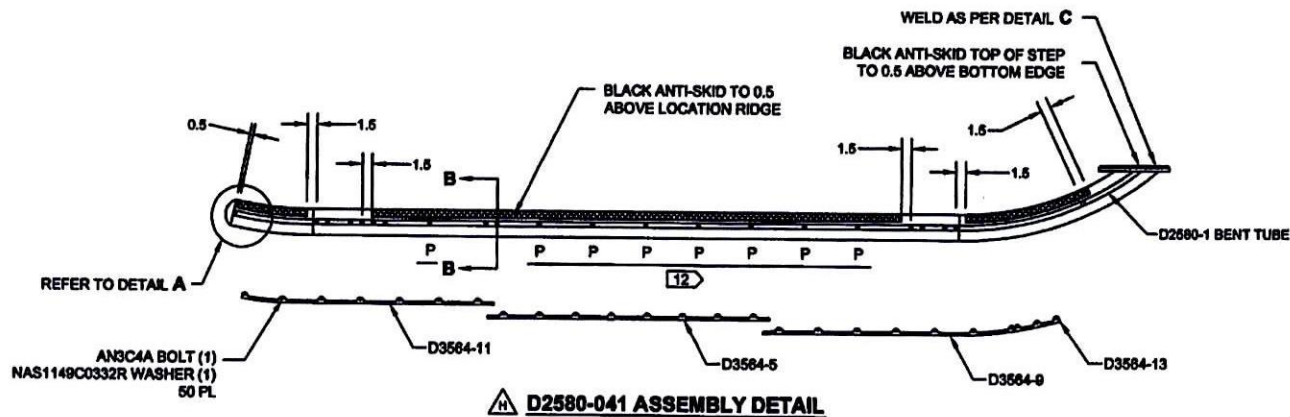
GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8637 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2565 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

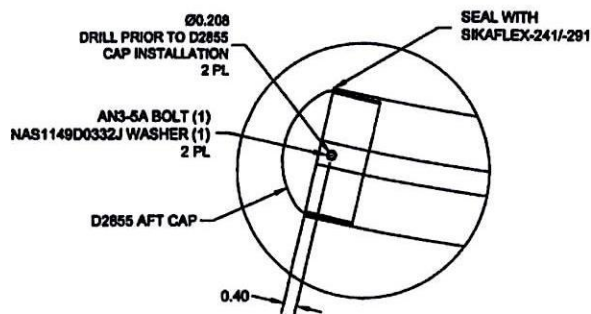
H	SHEET: PL DELETE D3586-1/5-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DSI 9096	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PART12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8637 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	06.06.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	TS	DRAWING NO.	REV. H
MFG. APPR.	TS	D2580	SHEET 1 OF 9
APPROVED	TS	TITLE	SCALE
DE APPR.	TS	205 SKIDTUBE ASSEMBLY	NTS
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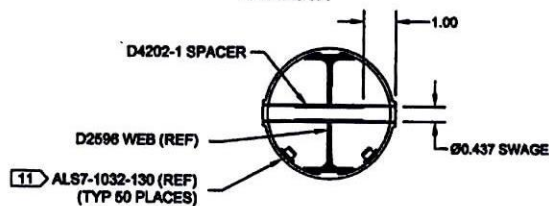
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DETAIL A
SCALE 5X

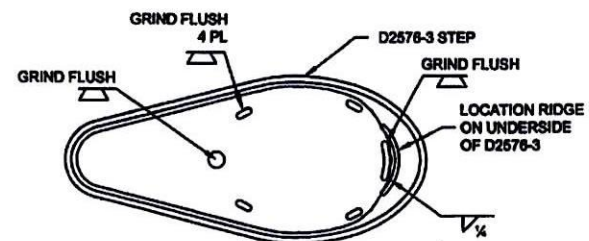


SECTION B-B
SCALE 5X



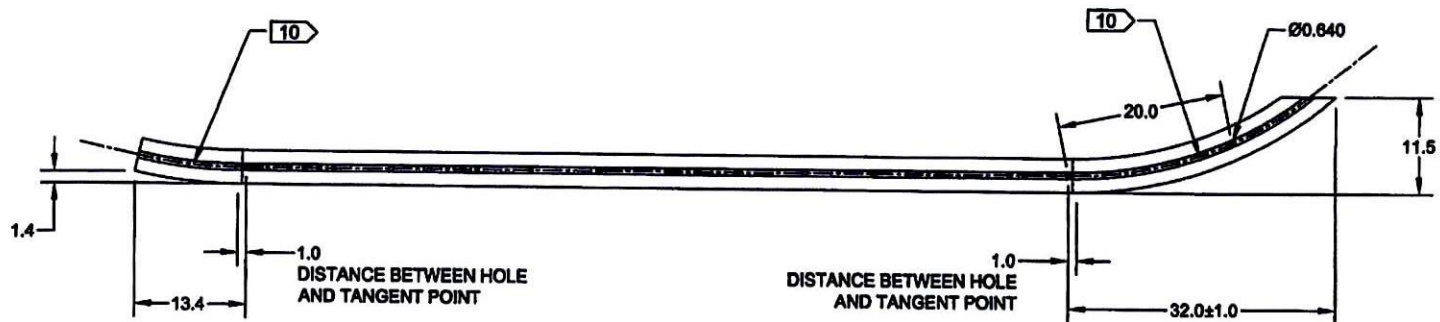
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DETAIL C
SCALE 5X



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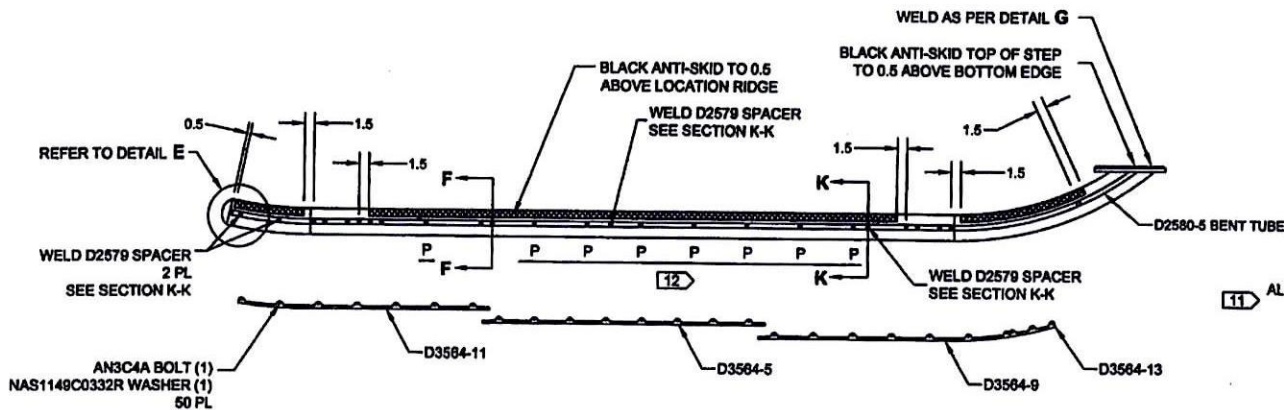
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

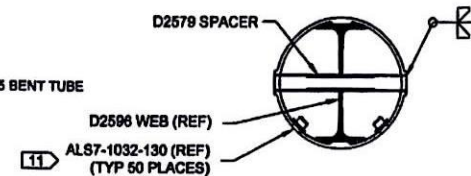
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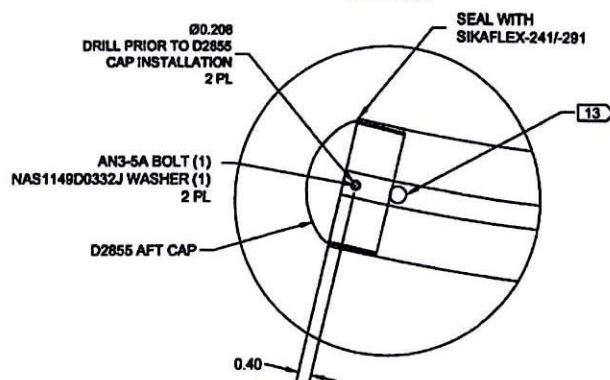
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
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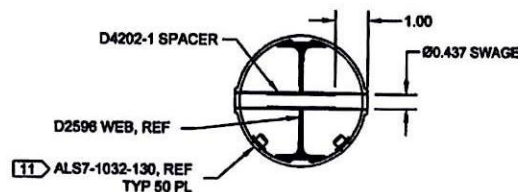


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**

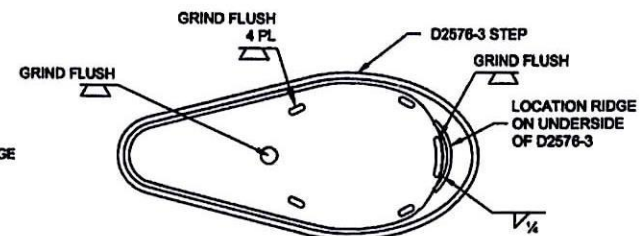


**SECTION F-F
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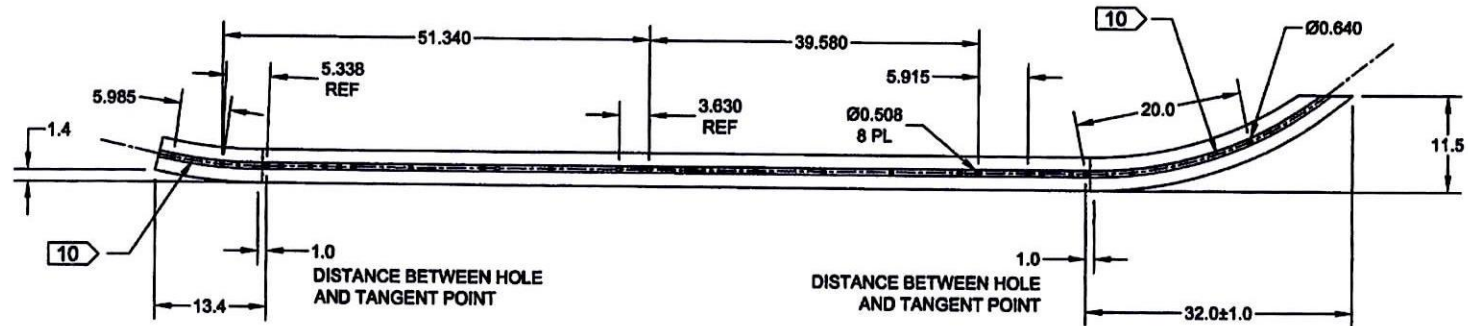
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
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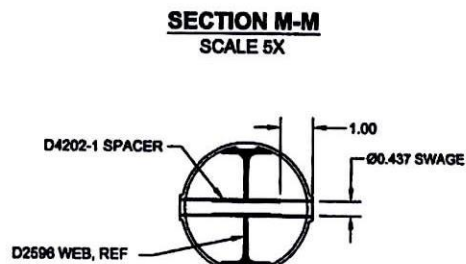
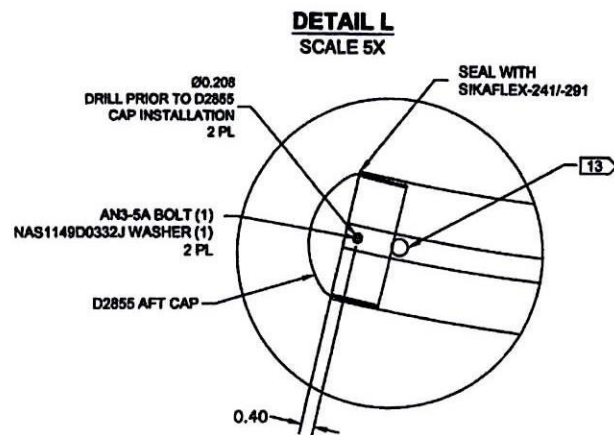
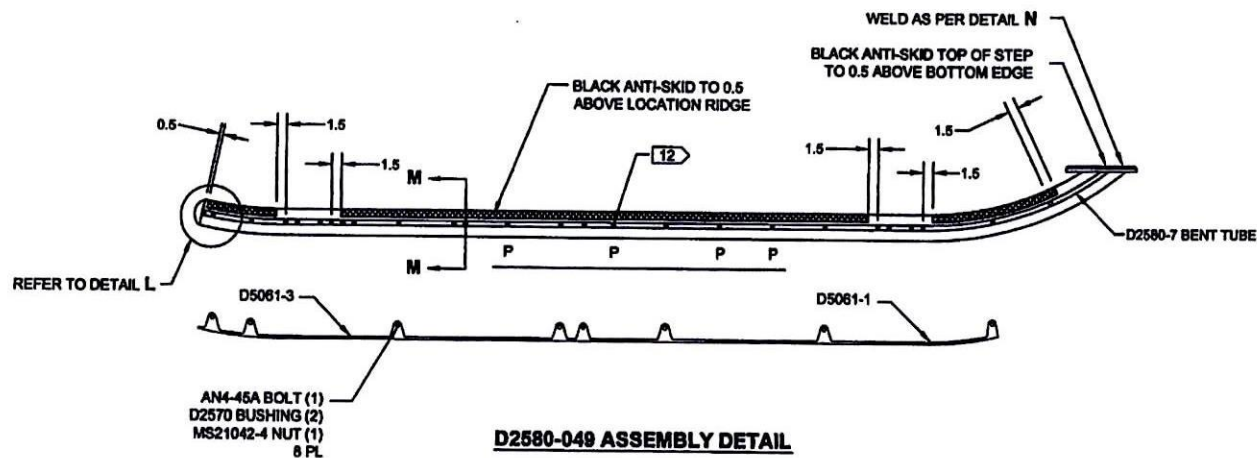
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D2580-5 BENT TUBE
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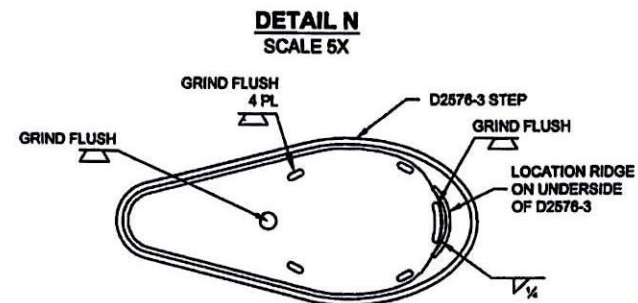
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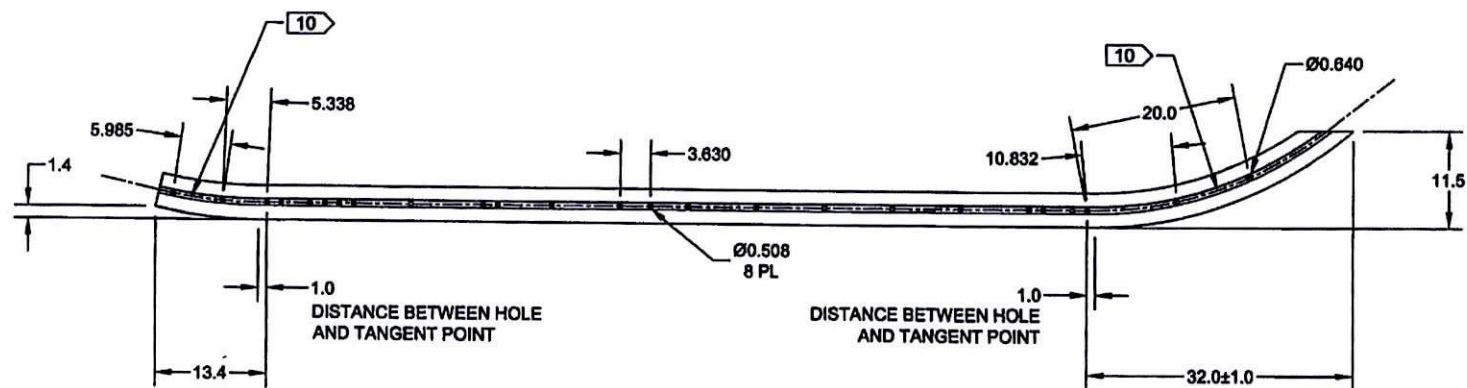
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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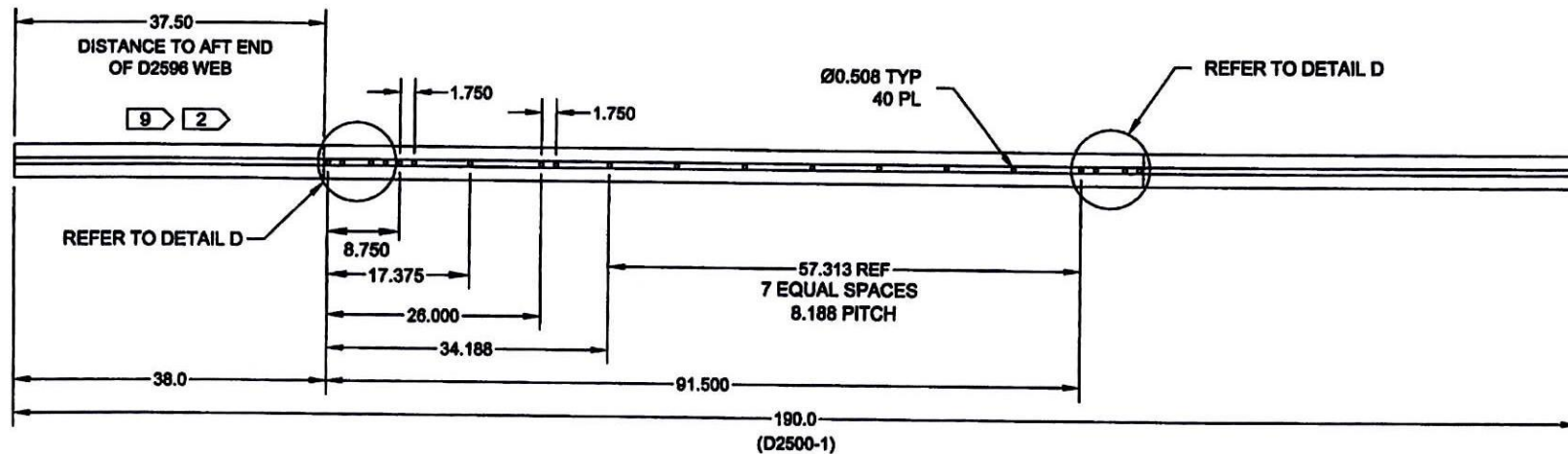
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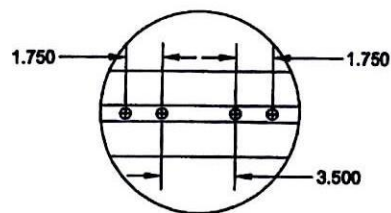
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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D2580-101 TUBE



DETAIL D
SCALE 5X

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8 7 6 5 4 3 2 1